

Date: Wednesday, 10/11/2006 12:49:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L WEB
 Job Number : 28934
 Estimate Number : 10722
 P.O. Number : N/A Part Number : D26547
 This Issue : 10/11/2006 S.O. No. : N/A Drawing Number : D2654 REV E1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E1
 Previous Run : 28238 Material : N/A
 Due Date : 10/20/2006 Qty: 8 Um: Each
 Written By : JA 061011
 Checked & Approved By : JA 061011
 Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedure DM
 Est Rev:e 06.04.05 Added level21 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26007125 Extrusion 'I Beam' thick



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2600-7- 125 Web

621130

ZT

06-10-18

(8)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

ZT 06-10-18 (8)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-10-18

(8)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.E 06/10/18

(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 28934

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-10-18 (8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 06-10-18 (8)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

06/10/19

Job Completion



U 06-10-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

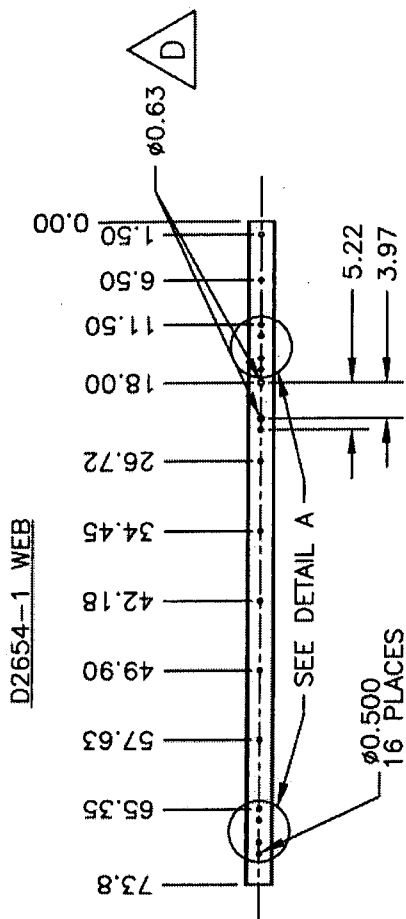
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

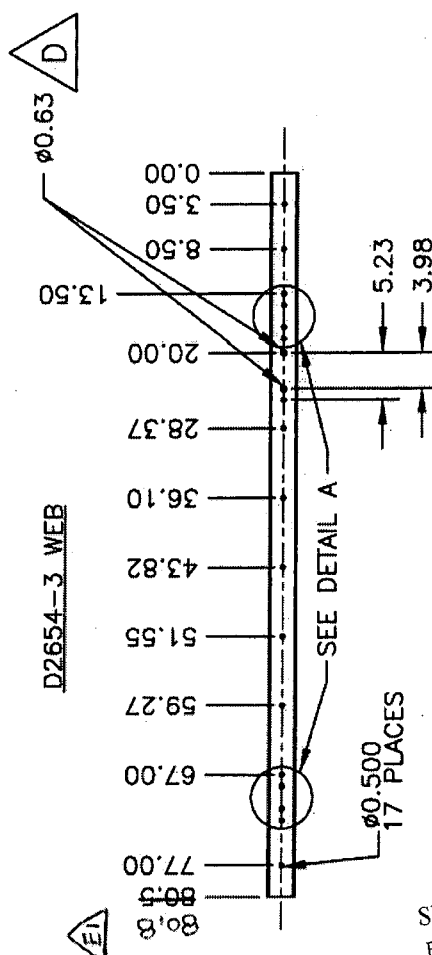
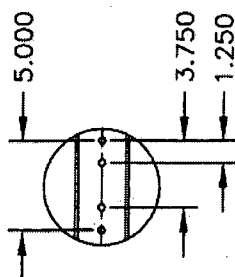


DESIGN CP		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #		APPROVED #		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26			TITLE WEB SCALE 1:20		
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO Ø0.63		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	CP #	04.08.04	PER TOOLING; Ø0.8 WAS Ø0.5		

RELEASED
04.06.22



DETAIL A
SCALE 1:10



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WORK ORDER
NO. 28734

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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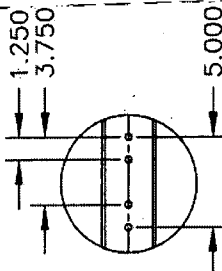
DART



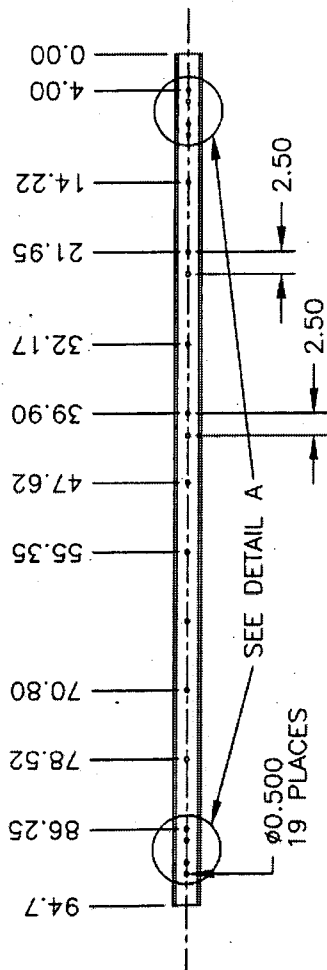
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED
04.06.22

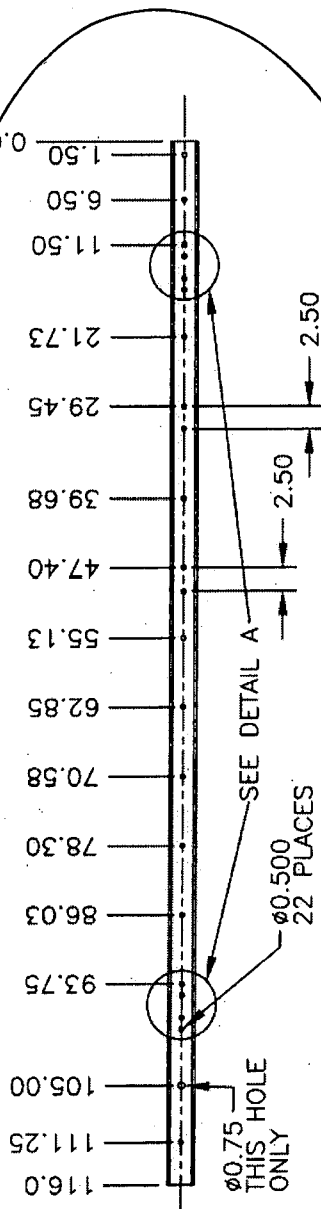
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
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